

Work Order ID 160343

Tuesday, April 25, 2017 3:20:13 PM

160343

Page 1

Item ID: D4018-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AS350 Short Basket Lid Assembly
Start Date: 4/28/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/3/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan:  Date: APR 25 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4018	D								
D4020	A								
100	Weld per dwg A/R S.S. rod Batch: <u>136695</u>	0.00							
100	Large Fab								
	Memo	2.03							
	1- assemble ribs , weld as per dwg D4018 using DT9607B								
	2- weld hinge (3) and Mounting brackets as per dwg D4018								
	inspect before welding mesh								
	3- Cut mesh as per dwg D4020-7								
	4- tack weld mesh on basket as per dwg D4018								
	make sure to place mesh correctly on lid, check with label plate before tacking mesh								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC								
	Memo	0.00							
	Quality Control								

136695 17-05-10

17-05-15

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120						①	17-05-15		
QC	Memo	0.02							
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130	M 136370.					1	Ø 1705-15.		DAS 34 9-89
Powdercoat	Memo	0.46							
Powder Coating	*** mask sides of hinge prior to powdercoat*** Start Time: 2:00 Oven Temperature: 320° Finish Time: 2:30								
140	Wing Walk as per dwg QSI005 4.4 Batch M137092	0.00							
140									1 n d 17/06/17
HandFinish	Memo	0.70							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***								

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Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							DAS 38 9-89
150									
QC	Memo	0.01							
Quality Control									MAY 17 2017
160	Identify as per dwg & Stock Location: <u>wlo</u>	0.00							
160									
Packaging	Memo	0.01							124032-041/13160105 12 d 22 12/12
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									17/5/18 JF
QC	Memo	0.10							
Quality Control									DAS 21 9-89 MAY 18 2017

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due								
		OTHER :							

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Parent Item: D4018-041

D4018-041

Parent Item Name: AS350 Short Basket Lid Assembly

Start Date: 4/28/2017

Required Date: 5/3/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	374.5000	8.4578	8,4578			
M304FX0 75-16F Expanded Metal Flat SS													
				<u>Location</u>		<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>					
				WA004			374.5						
				M136991			30.5						
				M137294			344						
D4018-1		Manufactured	No			100	Each	10.0000	2	2			
D4018-1 Rib													
				<u>Location</u>		<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>					
				WA004			10						
				146427			1						
				148048			1						
				157842			8						
D4018-3		Manufactured	No			100	Each	10.0000	2	2			
D4018-3 Rib													
				<u>Location</u>		<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>					
				WA004			10						
				148050			2						
				157841			8						

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 160343

160343

Parent Item: D4018-041

D4018-041

Parent Item Name: AS350 Short Basket Lid Assembly

Start Date: 4/28/2017

Required Date: 5/3/2017

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100 Each

54.0000

3

3

✓ *D4016-3*

Hinge Half, Lid

**

B159554 → 3x

17-05-10

Location

Loc Qty

Loc Code

WA004

54

154823

17

155384

37

D4018-5 Manufactured No

100 Each

27.0000

6

6

✓ *D4018-5*

Rib

**

B160807 → 6x

17-05-10

Location

Loc Qty

Loc Code

WA004

27

152954

6

157514

21

D4035-043 Manufactured No

100 Each

6.0000

2

2

✓ *D4035-043*

Lid Rib Assembly, Aft (350 Basket)

**

B160513 → 2x

17-05-10

Location

Loc Qty

Loc Code

WA004

6

157744

6

D2581 Manufactured No

100 Each

84.0000

2

2

✓ *D2581*

Mounting Bracket

**

B152803 → 2x

17-05-10

Location

Loc Qty

Loc Code

WA004

84

152803

38

157620

26

159116

20

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
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D4018-041

Parent Item Name: AS350 Short Basket Lid Assembly

Start Date: 4/28/2017

Required Date: 5/3/2017

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured No

100

Each

11.0000

1 1

✓ ***D4021-3***

Data Plate

** BSS883 → 17-05-10

Location

Loc Qty

Loc Code

WA004

11

155383

11

D2728-3

Manufactured Yes

140

Each

-1.0000

1 1

✗ ***D2728-3***

Dart Logo Label Large

** 17-05-10

DQA: _____ Date: _____

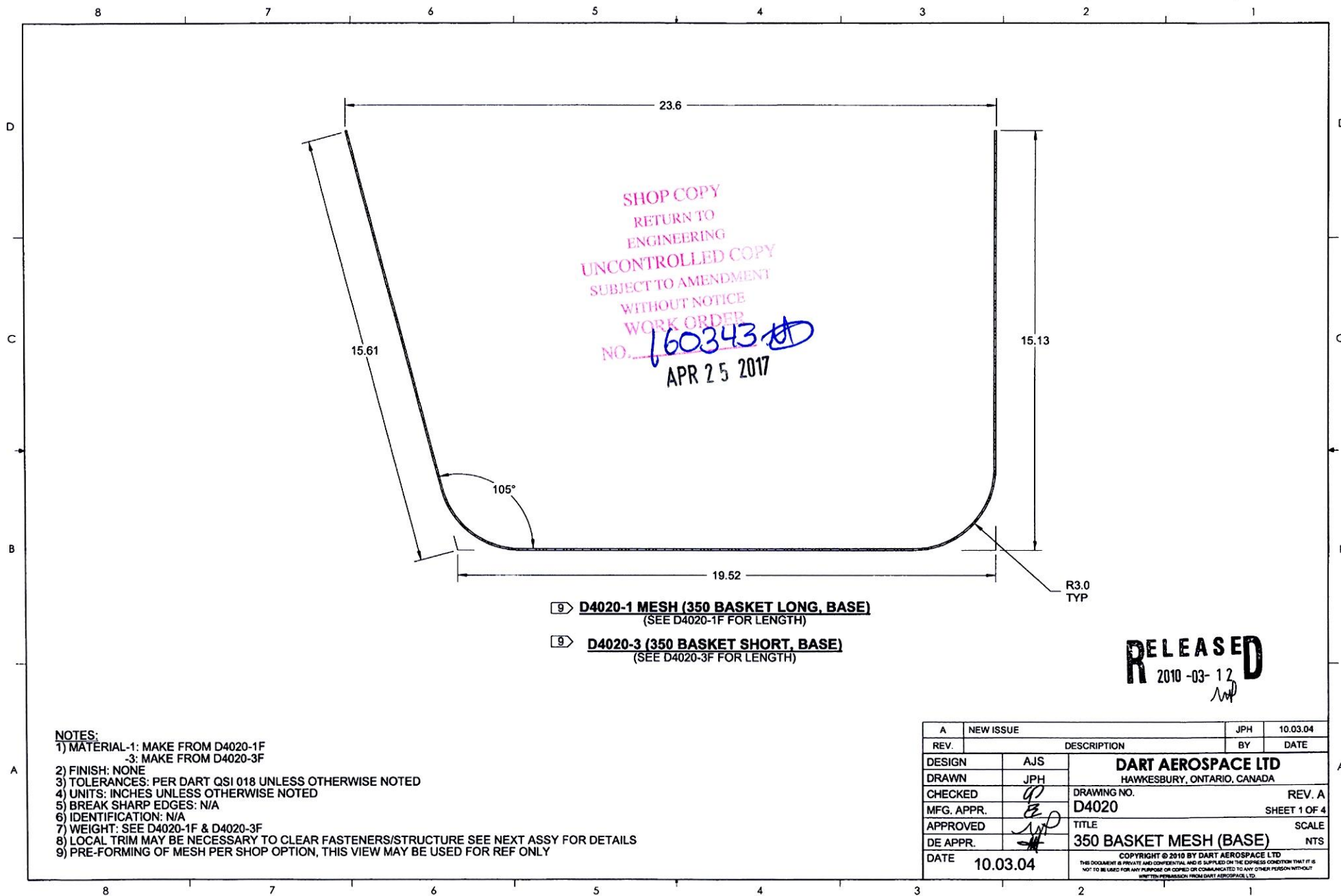


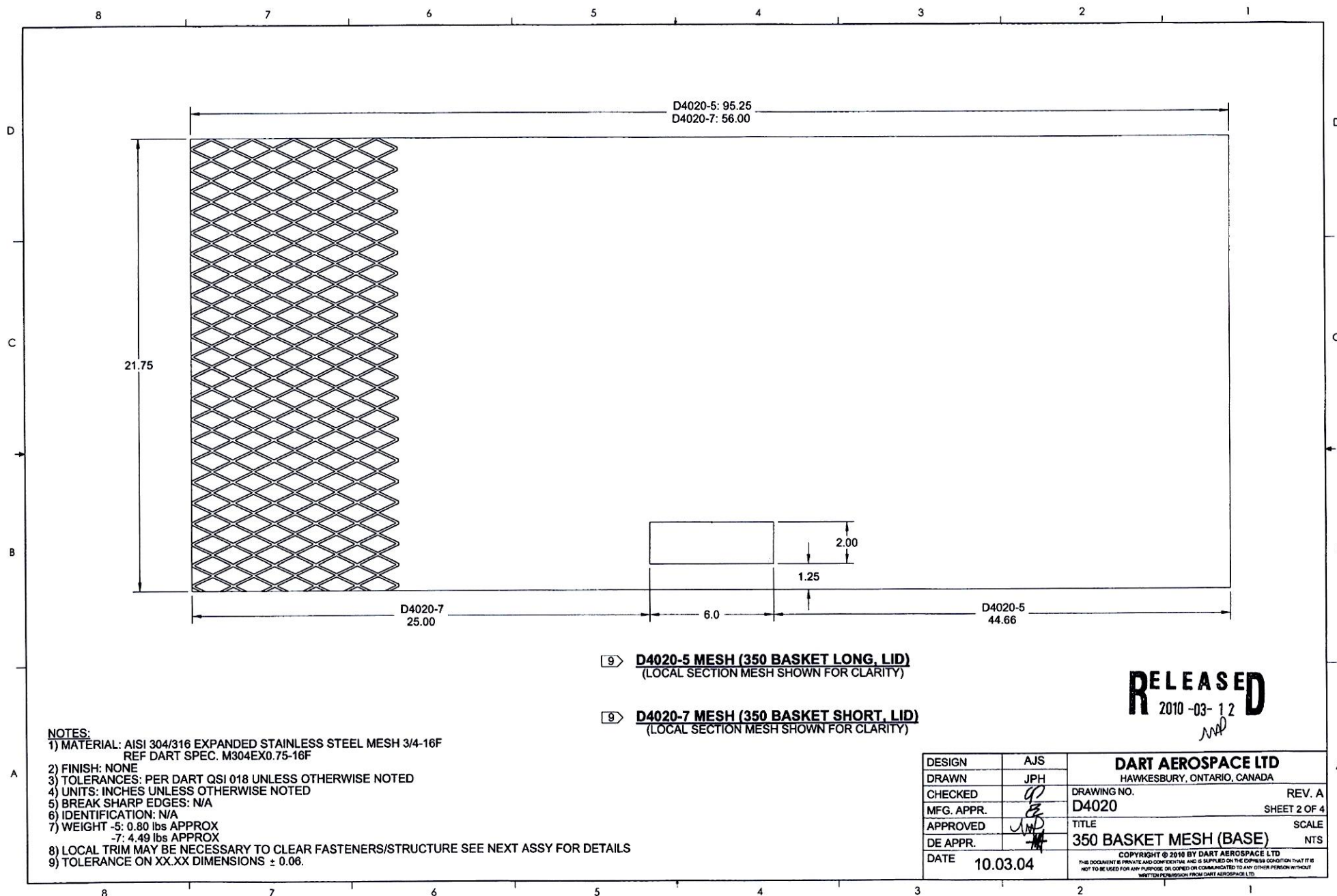
WORK ORDER NON-CONFORMANCE / UPDATE

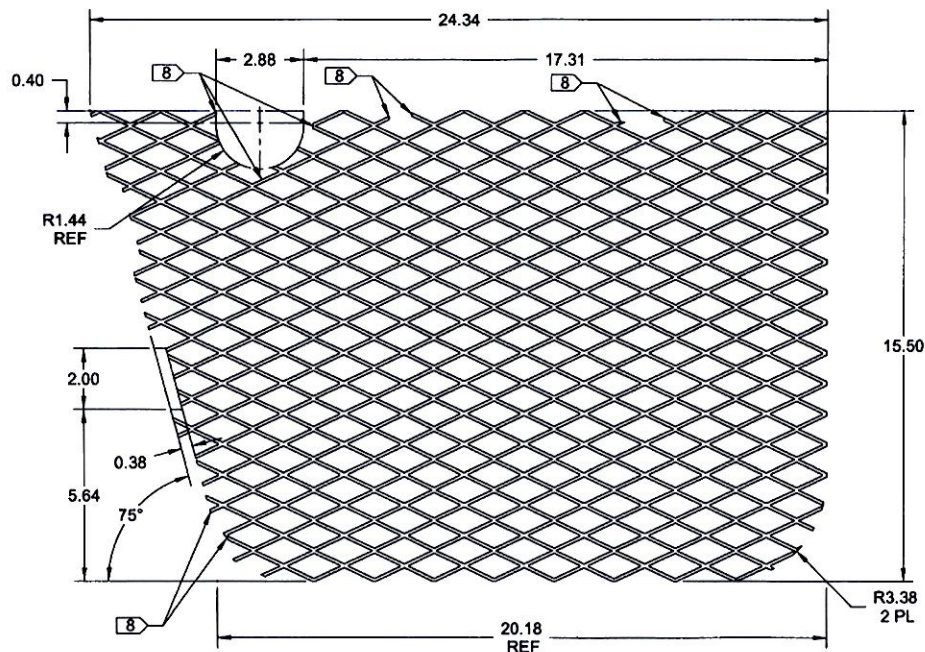
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		OTHER : ☐							







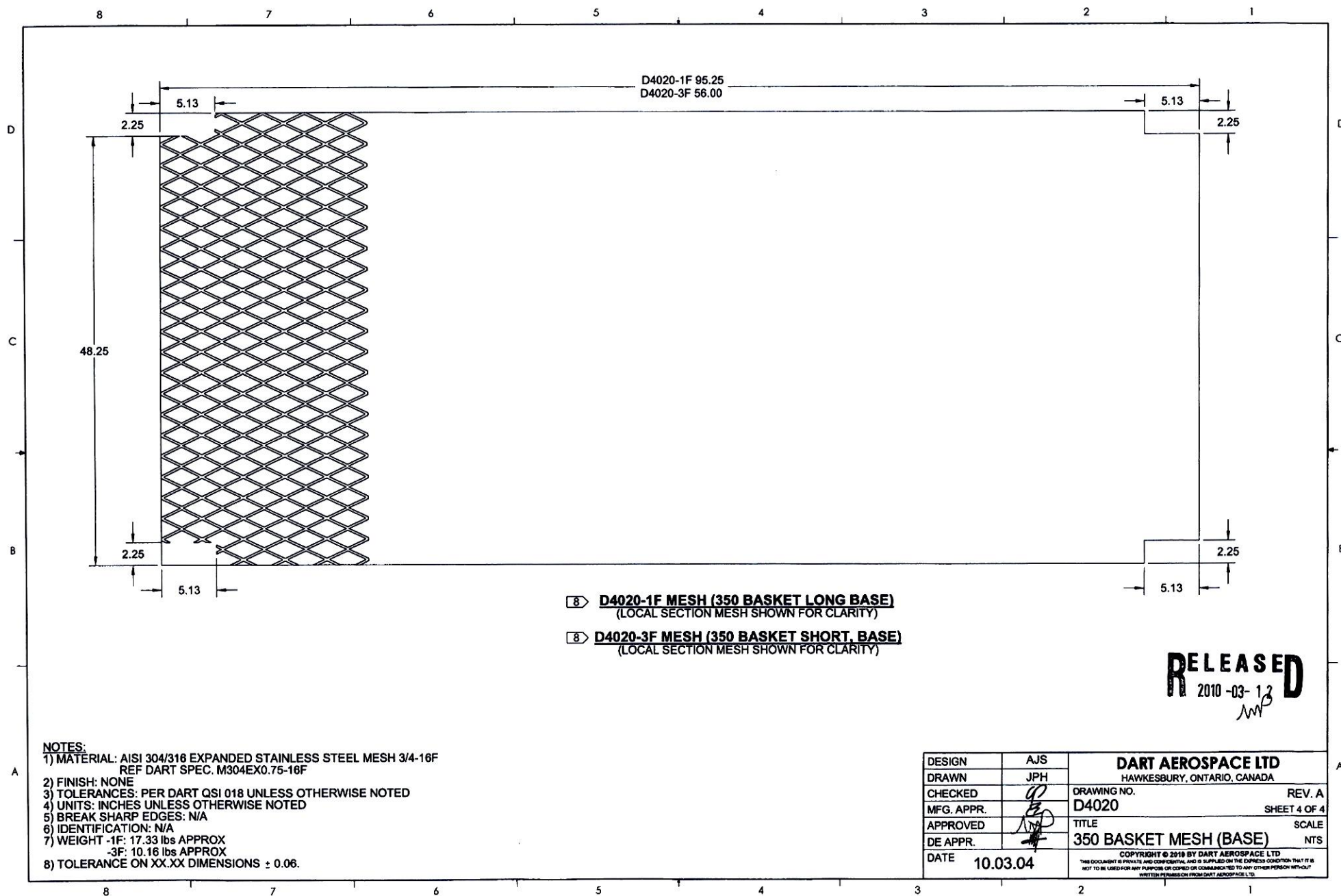
9 D4020-11 END MESH, BASKET

NOTES:

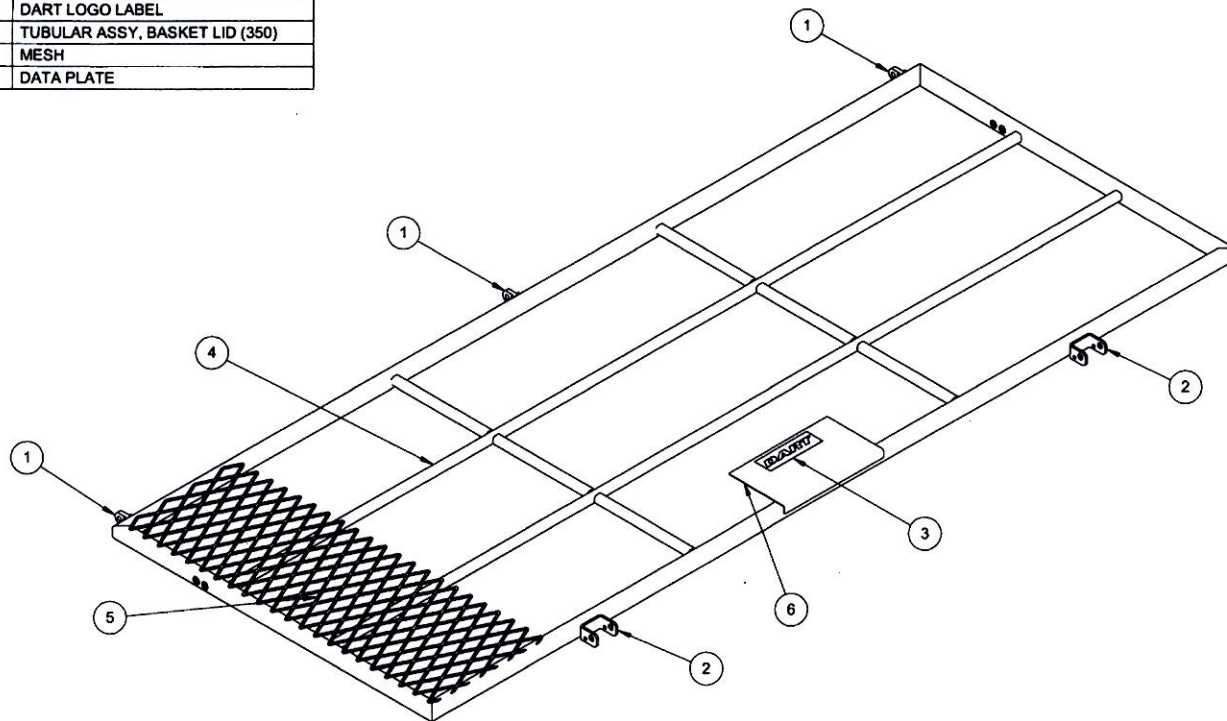
- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
JMP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A SHEET 3 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE 350 BASKET MESH (BASE)	SCALE NTS
APPROVED	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	<i>[Signature]</i>		
DATE	10.03.04		



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE

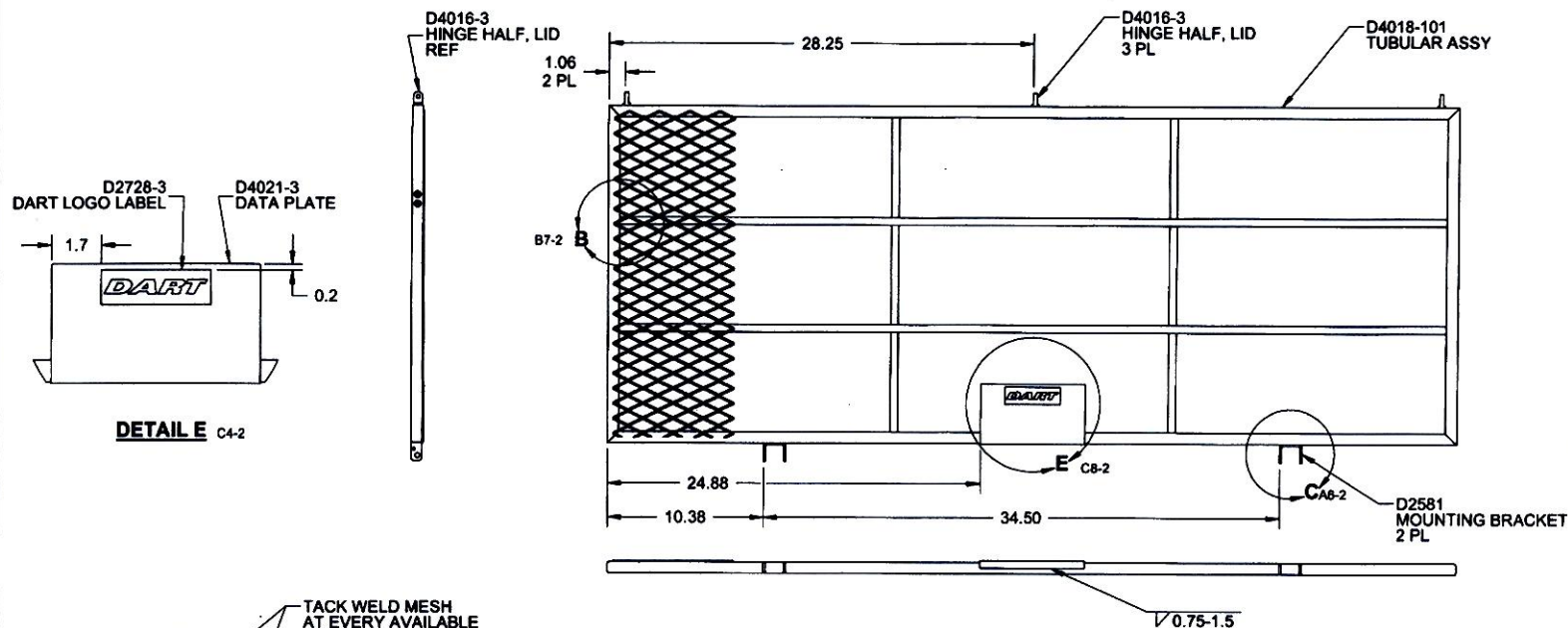


D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

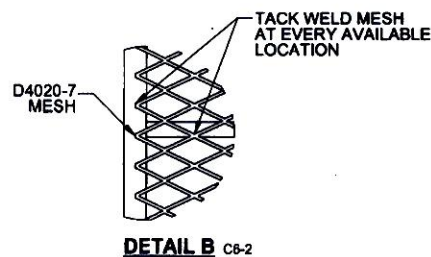
SHOP COPY
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NO. **160343**
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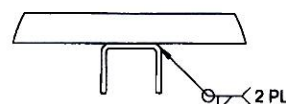
D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED).	AJS	13.07.18
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2. NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. D SHEET 1 OF 4 TITLE SHORT BASKET LID ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AJS		
CHECKED	Y		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.18		



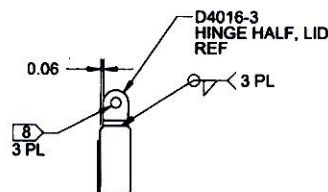
DETAIL E C4-2



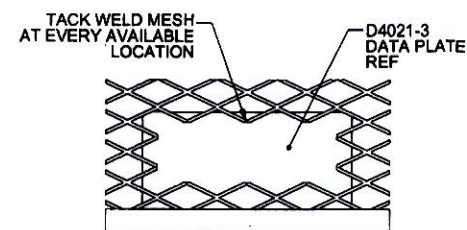
DETAIL B C8-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

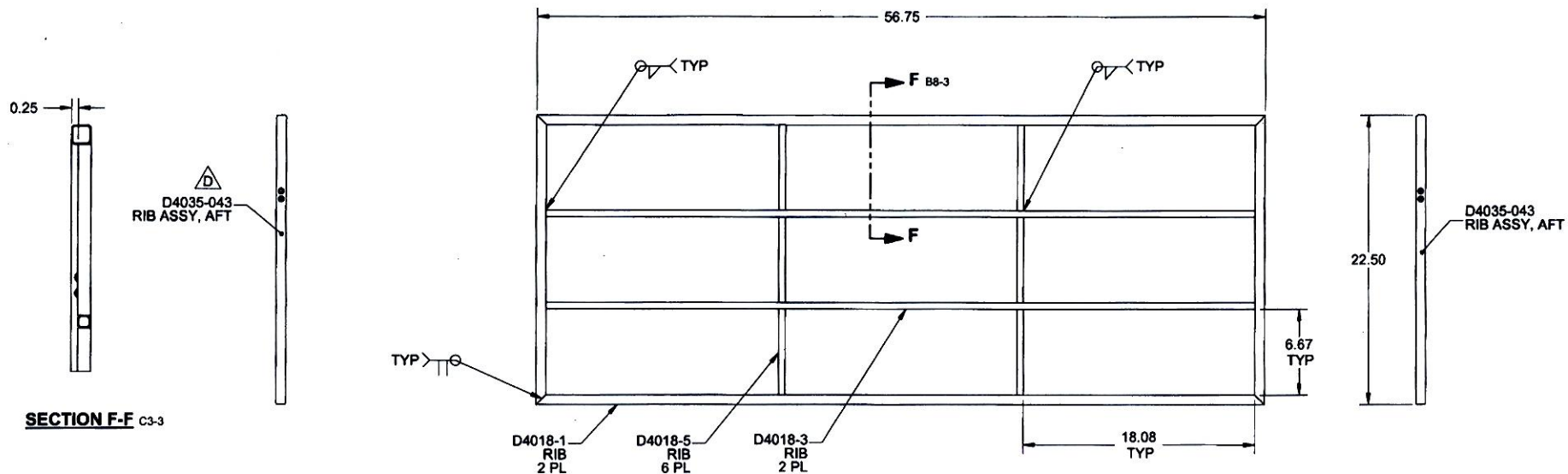
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

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MFG. APPR.	JP	D4018	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SHORT BASKET LID ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION F-F C3-3

8 D4018-101 TUBULAR ASSY, BASKET LID (350)

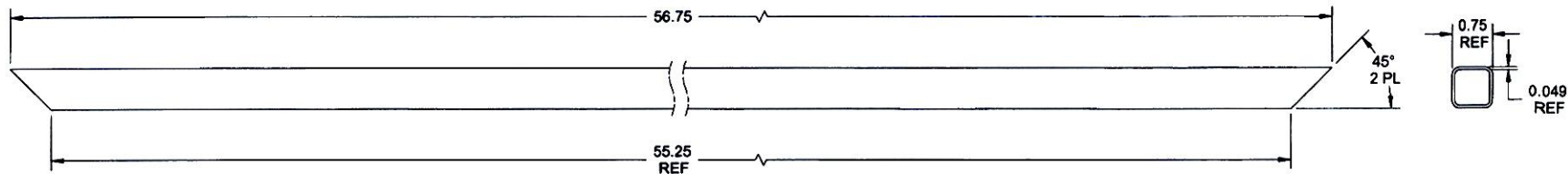
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NOTES:

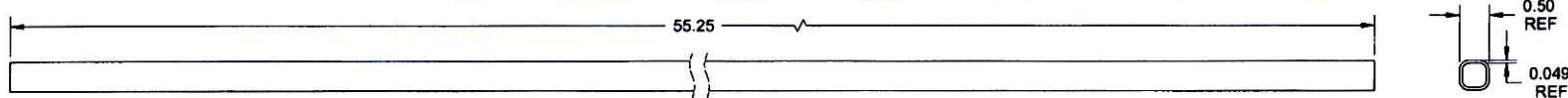
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY (350)	
DATE	13.07.18	NTS	

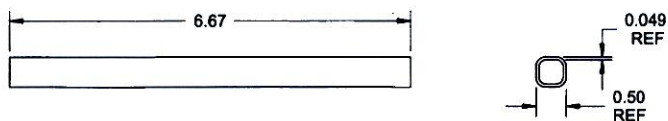
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D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4018	REV. D
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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